



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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DSK080

Job Sheet 191144



Part No: DSK080

Job Qty: 8 pcs 7

DAS
21
9-06

Part Name: D2896-1 Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/21/19

Job Tracking No:

Due Date: 3/15/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV A IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	8 pcs	3/15/19	3/15/19	0.00	11.43	Doosan - 1		PMP 2019-03-31
110	QC 2	8 pcs	3/15/19	3/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		SL 19-44
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

DAS
56
9-89

Plex 2/21/19 4:07 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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Other/Details:					

		QC 21 - SA - 70	APR 22 2019	
		QC 21 - SA - 53		
Part Op 100 - Doosan (Doosan Lathe) Turn blank as per Folio FA167 Descriptions: 110 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB) 120 - QC8 Machining-4 (QC8- Inspect parts - second check) 130 - Packaging3-2 (Identify as per dwg & Stock Location: _____) LOCATION: MAT060 140 - QC21 (QC21- Final Inspection - Work Order Release)				
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6104-011	17-4 SS Roundbar 6.50"OD	8 pcs (1 ea)	100-Doosan - 1	5150872 275552
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	D6104-011	8	21	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order:	191144
Description: Turning Detail for D2896-1		Part Number:	DSK080
Inspection Dwg: DSK080		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485		3.4835	3.484	3.4835	3.481	3.482
B	3.990	4.010		4.003	4.001	4.001	4.0015	3.999
C	3.825	3.845		3.835	3.834	3.835	3.835	3.8355
D	0.718	0.738		.727	.7295	.727	.7275	.727
E	0.090	0.110		.101	.101	.1015	.1005	.101
F	3.705	3.725		3.715	3.713	3.7135	3.713	3.7135
G	1.360	1.380		1.372	1.371	1.371	1.371	1.371
H	1.250	1.260		1.259	1.2565	1.257	1.2575	1.256
I	6.490	6.510		6.5005	6.500	6.500	6.500	6.500
J	0.022	0.042		.0315	.315	.315	.315	.315
K	0.240	0.260		.26	.26	.26	.26	.26
L	0.107	0.127		.116	.1165	.116	.117	.1165
M								
N								
O								
P								

Measured by:	JL 19.4.4	Date:	
Audited by:	DAS 52 9-89	Date:	18/09/10
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

Entered: _____ Date: _____



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C	3.825	3.845		3.835	3.835			
D	0.718	0.738		.726	.726			
E	0.090	0.110		.103	.103			
F	3.705	3.725		3.725	3.725			
G	1.360	1.380		1.378	1.371			
H	1.250	1.260		1.260	1.258			
I	6.490	6.510		6.500	6.500			
J	0.022	0.042		.032	.032			
K	0.240	0.260		.260	.260			
L	0.107	0.127		.117	.117			
M								
N								
O								
P								

Measured by: JL	Date: 19-4-4
Audited by: DAS 52 9-89	Date: 19/4/10
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
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Container No: S169569



Part: DSK080

Job No: 191144

Serial No/Batch: S169569

Revision:

Inspector:

Exp Date:

Instructions:

Date: 04/04/19